

October-01-13 10:15:52 AM

**Item ID:** D2346

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

**Item Name:** Spacer

Stop **\*NS2\***

**Start Date:** 10/01/13      **Start Qty:** 10.00

**\*10\***

**Cust Item ID:**

**Required Date:** 10/01/13      **Req'd Qty:** 10.00

**\*10\***

**Customer:**

**Reference:**

Approvals: \_\_\_\_\_ Process Plan: ✓ \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|                 |                     |
|-----------------|---------------------|
| <b>Draw Nbr</b> | <b>Revision Nbr</b> |
| D2346           | Rev B               |

100

0.00

**\*100\***

Hardinge CNC LATHE SMALL

Hardinge

## Memo

0.00

## Hardinge CNC Lathe Small

Machine as per folio FA198Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

# Work Order ID 107759

\*107759\*

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October-01-13 10:15:52 AM

Item ID: D2346 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Spacer  
 Start Date: 10/01/13 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 10/01/13 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Chemical Conversion Coat per QSI005 4.1 | 0.00                 |         |        |              |               |               |                  |                |
| *130*                          |   |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |   |                      |         |        |              |               |               |                  |                |
| 140                            | QC7-Inspect Chemical Conversion Coat    | 0.00                 |         |        |              |               |               |                  |                |
| *140*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 150                            | Identify as per dwg & Stock Location    | 0.00                 |         |        |              |               |               |                  |                |
| *150*                          |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo (4x) ship                          | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |

10 7613-80-1

40

10x 28 13-10-1

**Work Order ID 107759****\*107759\***

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October-01-13 10:15:52 AM

Item ID: D2346 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Spacer  
Start Date: 10/01/13 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 10/01/13 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

MLJ 13-10-01  
ME  
13-10-01

# Picklist Print

October-01-13 10:15:52 AM

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Work Order ID: 107759

Parent Item: D2346

Parent Item Name: Spacer

Start Date: 10/01/13

Required Date: 10/01/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP G02.03.05Re-format to machine in houseNG

| Component Item ID/<br>Item Name                   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6T0.375W.035<br>6061-T6 RD Tube .375 x.035W |                        | Purchased     | No          |                     |                  | 100             | f                  | 213.1722       | 0.1042      | 1.0968421    |               |                |        |

DAS 13/10/14  
40  
9-29

| Location | Loc Qty  | Loc Code |
|----------|----------|----------|
| MAT014   | 213.1722 |          |
| 112652   | 105.1722 |          |
| 124491   | 108      |          |

1.1



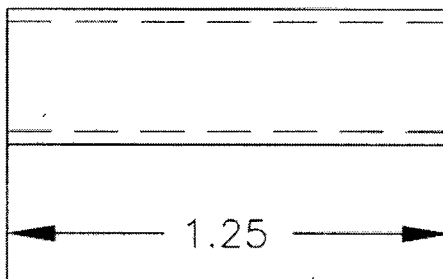


|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br>RF                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2346                              | REV. 8<br>SHEET 1 OF 1 |
| DATE<br>99.12.15              |                                | TITLE<br>SPACER                                   | SCALE<br>2:1           |
| A                             | 95.01.05                       | NEW ISSUE   |                        |
| B                             | 99.12.15                       | ADD FINISHING                                     |                        |

RELEASED  
(19.12.21 03)  
UNDER REVIEW

0163-15 CP

DESIGN OK, BUT CHECK WITH  
JB BEFORE MANUFACTURE



u/o 107759

MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES 0.010 TO 0.020